Body Lock Pillar Inner Panel Sectioning Replacement

Removal Procedure

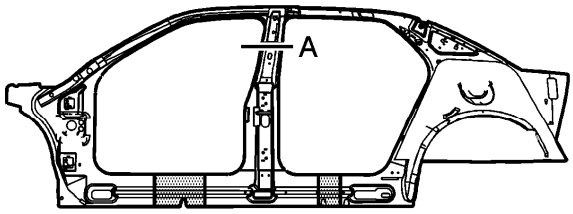
Caution: Refer to Approved Equipment for Collision Repair Caution in Cautions and Notices.

Caution: Sectioning should be performed only in the recommended areas. Failure to do so may compromise the structural integrity of the vehicle and cause personal injury if the vehicle is in a collision.

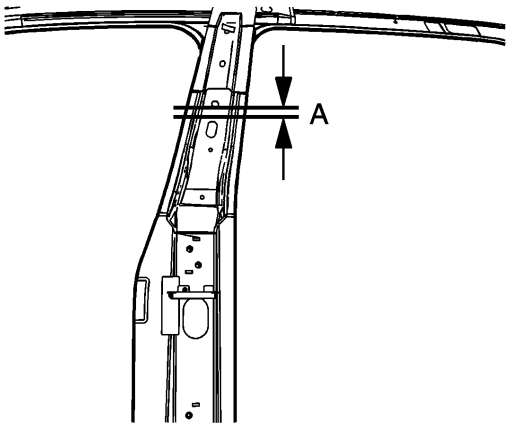
1. The body side inner panel is available in one piece. Sectioning must take place in specified areas only.

   Remove all related panels and components.

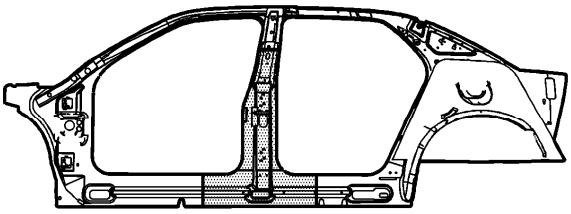
2. Disable the SIR system. Refer to SIR Disabling and Enabling .
3. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection .
4. Remove the sealers and anti-corrosion materials from the repair area, as necessary and note their location. Refer to Anti-Corrosion Treatment and Repair .
5. Remove any structural foam as necessary from between the inner rocker panel and the lock pillar-inner. Refer to Structure Foam Replacement .
6. Repair as much of the damaged area as possible. Refer to Dimensions - Body .



7. At the center pillar, locate the top round attachment hole (a).

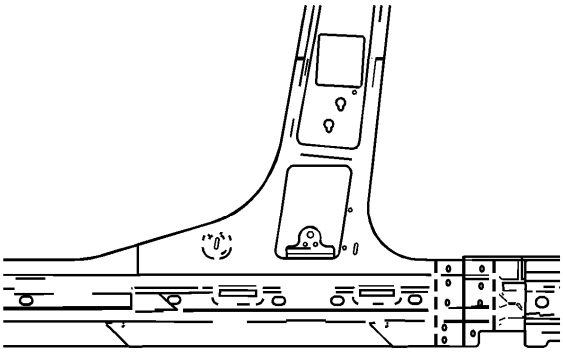


8. From the bottom of the round attachment hole (a), measure down 25 mm (1 in). Scribe a line.

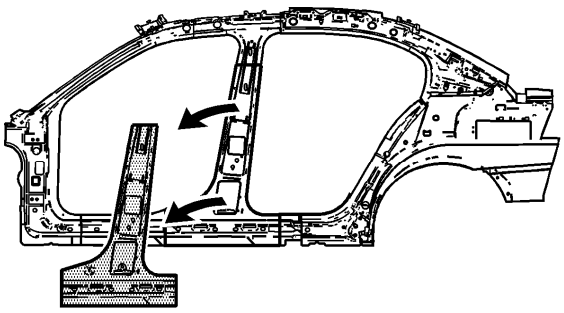


Important: Sectioning procedures can only take place in the straight areas of the inner body side panel.

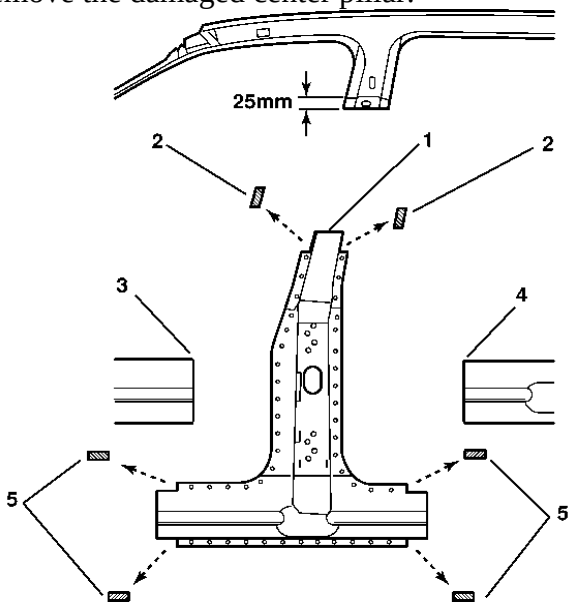
9. Measure from any key feature in the panel. Lay out the cut line location on the inner body side panel.
10. Create cut lines on the rocker panel within the approved sectioning locations as needed.
11. Cut the panel at the inner center pillar where the lay out line was scribed.



12. Cut the panel at the rocker panel area where sectioning is to be performed, within the straight sections only.



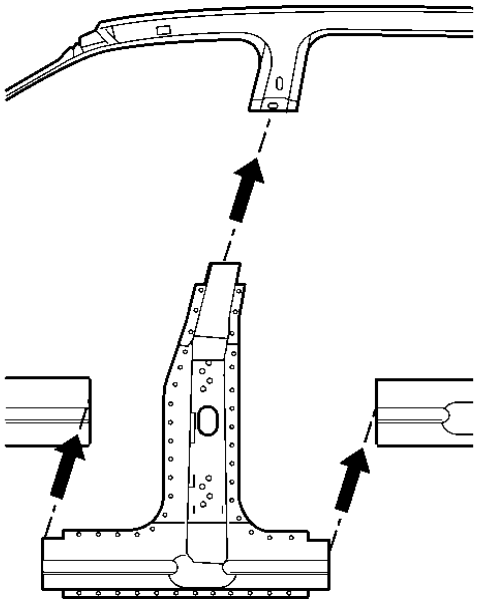
13. Locate and drill out all factory welds. Note the number and location of welds for installation of the service part.
14. Remove the damaged center pillar.



15. Cut the B-pillar at the bottom of the roundhole. This will allow a 25 mm (1 in) overlap to the vehicle for welding.
16. Notch the weatherstrip flange to prevent excessive metal thickness in these areas.
17. In the front and rear door rocker areas of service part, scribe vertical cut lines to allow 50 mm (2 in) overlap of original cut lines on the vehicle.
18. Drill 8 mm (5/16 in) plug weld holes every 40 mm (1 5/8 in) along the rocker overlaps, 25 mm (1 in) from the edge of the overlap. On the B-pillar, drill weld holes 10 mm (7/16 in) from the edge.

19. Drill 8 mm (5/16 in) plug weld holes on the weld flanges as noted from original panel.

Installation Procedure



Important: Prior to refinishing, refer to publication GM4901M-2000 "GM Approved Refinish Materials" for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

1. Prepare mating surfaces.
2. Prime the repair areas with two-part catalyzed primer.
3. Clamp the part in position. Check for proper fit.
4. Spot blast plug weld areas.
5. Plug the weld as necessary.
6. Stitch the weld along the sectioned areas.
7. Finish the seams as necessary.
8. Refinish as necessary.
9. Install all related panels and components.